Dec 17

Work Order ID 91115

October-03-12 8:54:55 AM

91115

Item ID: K10112 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Saddle, Skidtube 206

Start Date: 02/10/2012 **Start Qty:** 5.00 *5* **Cust Item ID:**

Required Date: 17/12/2012 **Req'd Qty:** 5.00 *5* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MLJ **Date:** 12-10-03 **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
DSI 9583	A
K10112	C

xSP

100 *100* DC Document Control — DOCUMENT CONTROL — 0.00

DAS 15 6-89

Memo 0.00 12 12 06

Photocopy bluefile &type labels per PPP K10112 CHG003
FOR D206-642-112 CHG008
FOR D206-642-114 CHG003

5 MLJ 12-11-27 (5)

110 *110* Packaging — Pick Kit — 0.00

Packaging — Memo — 0.00

5x SP 12-11-26.

DQA: ________ Date: ________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____ Part No. ____ NCR No. ____	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped.	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 91115

October-03-12 8:54:55 AM

91115

Item ID:	K10112	**Accept**	*N900040100*
Revision ID:		**Setup Start**	*NS1*
Item Name:	Saddle, Skidtube 206	**Stop**	*NS2*
Start Date:	02/10/2012	**Start Qty:** 5.00	*5*
Required Date:	17/12/2012	**Req'd Qty:** 5.00	*5*
Reference:		**Cust Item ID:**	
		Customer:	

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Run Start *NR1* **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness	0.00	DAS 15 8-89			5			
	Memo	0.00 12 12 06							
130 *130* Packaging Packaging	Packaging	0.00				5	12/12/6		DAS 20 8-89
	Memo Identify and pack for shipping as per PPP K10112 PPP D206-642-111 PPP D206-642-113 Location: PEG 014 PPP rev: ____	0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00					12/12/7		
	Memo	0.00							

MMF 12-12-06

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped.	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-03-12 8:54:59 AM

9

Work Order ID: 91115

91115

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 02/10/2012 **Required Date:** 17/12/2012

Start Qty: 5.00 **Required Qty:** 5.00

Comments: IPP : E00.06.14Changed GHW part # (mpp 2063)ECIPP REV:F 11.09.23 PER REV.B DD VERF:EC IPP REV:G 11.11.14 AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-651-041 *D206-651-041* 206A/B GHW		Manufactured	No			110	Each	9.0000	1 **	5	B91163		5
D2652 *D2652* Bushing		Manufactured	No			110	Each	565.0000	16 **	80	B91228 SP12-11-27		

D206-651-041 — SMB SY

Location	Loc Qty	Loc Code
FG122	1	
90216	1	
FG125	8	
79558	1	
83042	3	
87723	4	

D2652 — SMB SY

Location	Loc Qty	Loc Code
FG	44	
31985	44	
ST014	521	
73836	25	
81952	1	
88780	495	

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-03-12 8:54:59 AM

Work Order ID: 91115 *91115*

Parent Item: K10112 *K10112*

Parent Item Name: Saddle, Skidtube 206

Start Date: 02/10/2012 **Required Date:** 17/12/2012

Start Qty: 5.00 **Required Qty:** 5.00

D3413-1 Manufactured No 110 Each 45.0000 1 5

D3413-1

Ring

B91117

SP 12-12-5

Location		Loc Qty	Loc Code
ST420		8	
	86562	8	
ST421		10	
	88025	10	
ST464		27	
	80224	4	
	83307	3	
	83867	18	
	90009	2	

D2661-2 Manufactured No 110 Each 20.0000 2 10

D2661-2

Saddle, RH Fwd Aft Out 206

91219 JB 12/12/04

Location		Loc Qty	Loc Code
MEZZ		6	
	10015	1	
	10016	1	
	10476	3	
	9913	1	
ST434		14	
	80990	14	

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

	DISPOSITION	AGAINST DEPARTMENT/PROCESS
Work Order: ____________	Rework ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Part No. ____________	Scrap ☐	Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
NCR No. ____________	Use-as-is ☐	Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
	Work Order Update ☐	Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-03-12 8:54:59 AM

Work Order ID: 91115

91115

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 02/10/2012 **Required Date:** 17/12/2012

Start Qty: 5.00 **Required Qty:** 5.00

D2662-2 *D2662-2* Saddle, RH In 206 | Manufactured | No | 110 | Each | 19.0000 | 2 | 10 | ** | B91225 SP

SMB SX

Location	Loc Qty	Loc Code
Mezz	2	
11028	4	
9042	3	
9043	2	
ST434	10	
80992	9	
83491	1	

D2712 *D2712* Set Screw | Manufactured | No | 110 | Each | 717.0000 | 10 | 50 | ** | B 91229 SP

SMB SP

Location	Loc Qty	Loc Code
FG	50	
29962	50	
ST016	417	
84433	117	
86911	300	
ST019	250	
87644	250	

D2884 *D2884* Saddle Spacer | Manufactured | No | 110 | Each | 71.0000 | 2 | 10 | ** | B91231 SP 12-11-26.

SMB SX

Location	Loc Qty	Loc Code
FG	10	
29453	10	
ST020	61	
76751	19	
90494	42	

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order:	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No.	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No.	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-03-12 8:54:59 AM

Work Order ID: 91115 *91115*

Parent Item: K10112 *K10112*

Parent Item Name: Saddle, Skidtube 206

Start Date: 02/10/2012 **Required Date:** 17/12/2012

Start Qty: 5.00 **Required Qty:** 5.00

D2885 Manufactured No 110 Each 20.0000 2 ** 10

D2885

Saddle Spacer

B91233 SP

SMB SP

Location		Loc Qty	Loc Code
FG		10	
	29199	10	
ST020		10	
	76752	10	

AN3-41A Purchased No 110 Each 197.0000 8 ** 40

AN3-41A

Bolt

M123355 SP

SMB SP

Location		Loc Qty	Loc Code
FG		18	
	122416	18	
ST354		179	
	121243	179	

AN4C5A Purchased No 110 Each 330.0000 1 ** 5

AN4C5A

BOLT

SP 12-11-26

SMB SP

Location		Loc Qty	Loc Code
ST355		330	
	112243	129	
	119017	10	
	122599	191	5X

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	________	________
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	________	________
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________	________
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-03-12 8:54:59 AM

Work Order ID: 91115 *91115*

Parent Item: K10112 *K10112*

Parent Item Name: Saddle, Skidtube 206

Start Date: 02/10/2012 **Required Date:** 17/12/2012

Start Qty: 5.00 **Required Qty:** 5.00

AN4-6A | Purchased | No | 110 | Each | 1,141.000 | 12 | 60

AN4-6A **

Bolt

Location		Loc Qty	Loc Code
ST355		641	
	122808	600	
	123021	41	
ST356		500	
	121243	500	

AN5-10A | Purchased | No | 110 | Each | 313.0000 | 4 | 20

AN5-10A **

Bolt

Location		Loc Qty	Loc Code
ST337		213	
	118191	80	
	121243	100	
	122151	33	
ST362		100	
	122800	100	

AN5-11A | Purchased | No | 110 | Each | 286.0000 | 4 | 20

AN5-11A **

Bolt

Location		Loc Qty	Loc Code
ST337		286	
	118191	13	
	119512	273	

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped.	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ______
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	______	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	______	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	______	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID: 91115

91115

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 02/10/2012 **Required Date:** 17/12/2012

Start Qty: 5.00 **Required Qty:** 5.00

AN6-44A Purchased No 110 Each 43.0000 2 10

AN6-44A

Bolt

** M123265 SP

SMB SY

Location		Loc Qty	Loc Code	
ST340		30		
	122416	30		
ST343		7		
	119127	7		
st510		6		
	119036	6		

NAS1149D0363J Purchased No 110 Each 3,625.000 8 40

NAS1149D0363J

Washer

** SP 12-11-26

SMB SY

Location		Loc Qty	Loc Code	
ST297		3446		
	122378	3446		40X
ST298		179		
	117601	61		
	119537	33		
	120308	17		
	121524	68		

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

	DISPOSITION	AGAINST DEPARTMENT/PROCESS
Work Order: ____________	Rework ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Part No. ____________	Scrap ☐	Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
NCR No. ____________	Use-as-is ☐	Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
	Work Order Update ☐	Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-03-12 8:54:59 AM

Work Order ID: 91115

91115

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 02/10/2012 **Required Date:** 17/12/2012

Start Qty: 5.00 **Required Qty:** 5.00

NAS1149D0463J Purchased No 110 Each 3,443.000 24 120

NAS1149D0463J

Washer

** m123355 SP.

Location		Loc Qty	Loc Code
298		186	
	122441	186	
ST298		3219	
	104746	1	
	116805	0	
	119073	20	
	122452	3198	
ST299		38	
	121912	38	

NAS1149D0563J Purchased No 110 Each 3,920.000 8 40

NAS1149D0563J

Washer

** m123355 SP

Location		Loc Qty	Loc Code
ST298		3920	
	121255	920	
	122452	3000	

NAS1149D0663J Purchased No 110 Each 774.0000 4 20

NAS1149D0663J

Washer

** m123265 SP.

Location		Loc Qty	Loc Code
ST294		774	
	123021	774	

DQA: ________ Date: ________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**
Part No. ________	Rework ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
NCR No. ________	Scrap ☐	Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
	Use-as-is ☐	Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
	Work Order Update ☐	Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-03-12 8:54:59 AM

Work Order ID: 91115

91115

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 02/10/2012 **Required Date:** 17/12/2012

Start Qty: 5.00 **Required Qty:** 5.00

MS21042L3 | Purchased | No | 110 | Each | 1,946.000 | 8 | 40

MS21042L3

Nut

Location		Loc Qty	Loc Code
316		717	
	122452	717	
ST300		344	
	117885	32	
	119017	174	
	119075	138	
ST317		885	
	122141	885	

MS21042L4 | Purchased | No | 110 | Each | 5,329.000 | 12 | 60

MS21042L4

Nut

Location		Loc Qty	Loc Code
314		2302	
	122452	2302	
ST300		27	
	119017	20	
	121444	7	
ST314		3000	
	123021	3000	

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-03-12 8:54:59 AM

Work Order ID: 91115

91115

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 02/10/2012 **Required Date:** 17/12/2012

Start Qty: 5.00 **Required Qty:** 5.00

MS21042L6 Purchased No 110 Each 691.0000 2 10

MS21042L6

Nut

Location		Loc Qty	Loc Code
314		412	
	122441	412	
ST300		279	
	117677	25	
	118384	3	
	118927	48	
	119075	4	
	120308	199	

NAS1149C0463R Purchased No 110 Each 637.0000 1 5

NAS1149C0463R

Washer

Location		Loc Qty	Loc Code
FP001		1	
	115358	1	
ST297		636	
	117735	17	
	119097	619	

DQA: ________ Date: ________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ________ Part No. ________ NCR No. ________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**
	Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-642 REV. O AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 4
REF FAA STC: SA00475SE
REF CANADIAN STC: SH98-4
REF EASA STC: EASA.IM.R.S.01320

PROCEDURE:

FOR D206-642-113/-114 SKIDTUBE INSTALLATION KITS, IT HAS BEEN DETERMINED THAT AN5-10A (FWD) AND AN5-11A (AFT) BOLTS ARE MORE APPROPRIATE BOLT LENGTHS FOR ATTACHING THE SKIDTUBES TO THE CROSSTUBES THAN THE AN5-7A BOLTS PREVIOUSLY PROVIDED IN THE KITS.

4.2 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)
32.12 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

ITEM	QTY. -113	QTY. -114	PART NUMBER	DESCRIPTION
	X		D206-642-113	SKIDTUBE INSTALLATION, LH
		X	D206-642-114	SKIDTUBE INSTALLATION, RH

IS:

ITEM	QTY. -113	QTY. -114	PART NUMBER	DESCRIPTION
13	4	4	AN5-10A	BOLT
14	4	4	AN5-11A	BOLT

WAS:

ITEM	QTY. -113	QTY. -114	PART NUMBER	DESCRIPTION
13	4	4	AN5-7A	BOLT
14	4	4	AN5-7A	BOLT

FOR FURTHER DETAILS REFER TO PAGE 22, DETAIL A OF IIN-D206-642 REV. O, OR PAGE 30, DETAIL A OF ICA-D206-642 REV. 4.

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	AJS	11.11.02

DESIGN	AJS	DART AEROSPACE USA, INC KENT, WA
DRAWN	AJS	
CHECKED	[signature]	DRAWING NO. DSI 9583 — REV. A, SHEET 1 OF 1
MFG. APPR.	N/A	
APPROVED	[signature]	TITLE: BOLT SUBSTITUTION — SCALE: NTS
DE APPR.	[signature]	
DATE	11.11.02	

REFERENCE ONLY SMB

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-112
BELL 206 A/B	D206-642-114

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10112	D206-642-112	D206-642-114
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-2	2	2	2
5	D2662-2	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

REV.	DESCRIPTION	BY	DATE
C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-114	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED	[signature]	DRAWING NO. K10112 — REV. C, SHEET 1 OF 1
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE SADDLE KIT — SCALE NTS
DE APPR.	[signature]	
DATE	11.11.10	